

Date: Tuesday, 7/17/2007 2:00:32 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING	
Job Number	: 33590				
Estimate Number	: 10517				
P.O. Number	: N/A		Part Number	: D28061	
This Issue	: 7/17/2007 S.O. No. : N/A		Drawing Number	: D2806 REV A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 32773		Material	: N/A	
Written By			Due Date	: 7/24/2007	
Checked & Approved By			Qty:	62	
Comment	: Est:B 05.03.11 Part now turned KJ/JLM		Um:	50	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 1" HexBar 
Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000) Batch: 102608 29 07/07/20		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA105 and Dwg D2806 2-Tumble		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 29 07/07/20		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Drill as per Dwg D2806		
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/08/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33590

Part Number: D28061

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/17/08/10

Job Completion



C7/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33590
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: RD      Date: 07/07/20

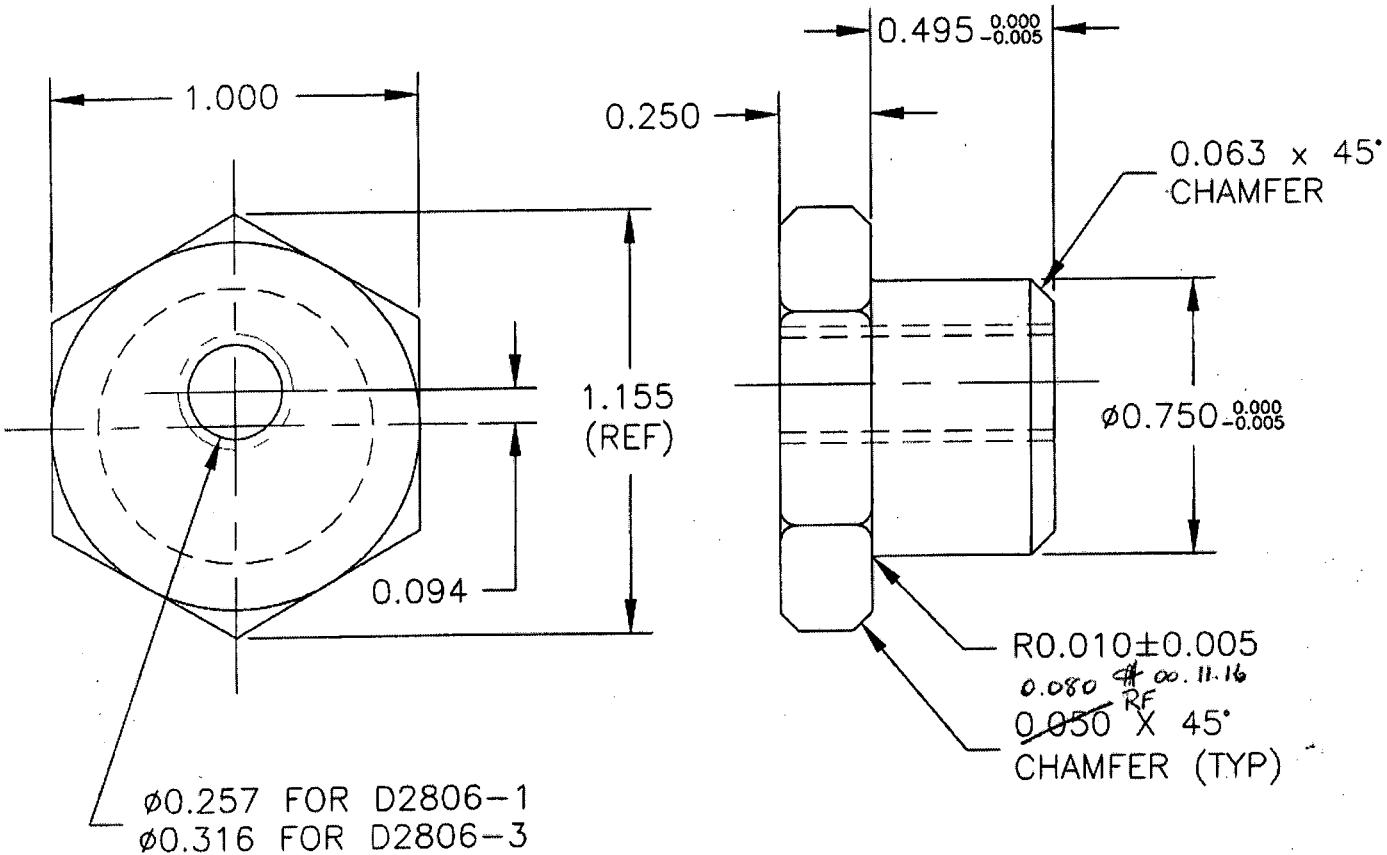
Audited by:	
Date:	07.08.05

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	TT

**DART**CA COPY IS  
MAILED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

**RELEASED**  
00.11.13

D2806-1 (DRILL Ø0.257 HOLE)  
D2806-3 (DRILL Ø0.316 HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

ROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 33590

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